

208748



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2646

Job Sheet 213469



Part No: D2646

Job Qty: 50 pcs

Part Name: Aft Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/28/20

Job Tracking No:

Due Date: 10/20/20

Created By: Dana Andrews

Type: Stock

Description:

Note: DWG REV C IPP: G 05.08.22 Hole size revised in Step 5 KJ/JLM IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing	50 pcs		10/19/20	0.00	0.00	Purchasing - 1		NOV 04 2020
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	50 pcs		10/19/20	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		NOV 04 2020
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S310853



Part: D2646

Job No: 213469

Serial No/Batch: S310853

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/04/20

Plex 9/28/20 12:56 PM Dart.Andrews.Dana

P.T.O.

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120	QC 6	50 pcs	10/19/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
130	Small Fab - 2 - B4B	50 pcs	10/19/20	0.00 2.01	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
140	QC 5	50 pcs	10/19/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
150	Handfinish - 1-1 Chemical-B4B	50 pcs	10/19/20	0.00 1.78	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	

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NOV 11 2020

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DEC 11 2020
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BFB 08/12/2020

					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White GI(A)- B4B	50 pcs	10/19/20	0.00 0.71	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-12-9
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
170	QC 3	50 pcs	10/19/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	20-12-9
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
180	Small Fab - 3 - B4B	50 pcs	10/20/20	0.00 2.01	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	20-12-9

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
210	QC 21 - SA	50 pcs	10/20/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

DAS

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DEC 09 2020

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DEC 08 2020

Part Op 100 - (Purchasing) Issue P/O: _____ 1-Spin as per Dwg D2646 2-Material release note required Vendor:
 Descriptions: Sieg's Manufacturing

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached

120 - (QC6- All purchased or subcontracted products)

130 - (Small Fab) 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - START TIME: _____ Oven Temp: _____ Finish Time: _____

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Install inserts as per Dwg D2646

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2646P	Aft Cap	50 pcs (1 ea)	100-Purchasing	S310852-
ALS7-1032-130	Rivnut	100 Ea (2 ea)	180-Small Fab - 3 - B4B	S315900

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2646P	50	0	0
180-Small Fab - 3 - B4B	ALS7-1032-130	100	1,361	0

Part Specifications

Specifications could not be found.

Plex 9/28/20 12:56 PM Dart.Andrews.Dana



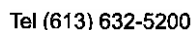
Sieg's Manufacturing Ltd.
6236 205 Street Langley, BC Canada V2Y 1N7
Ph:(604) 530-7455
Website: www.siegsmf.com

Packing Slip

Packing Slip No.: 3101
Date: 10/28/20
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7	Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7
Order No.: 47217	Sold By: Kale Quewezance
Shipped By:	Ship Date: 10/28/20
Tracking No.:	

Item No.	Unit	Description	Quantity
1	each	D2646P Aft Cap	50
RECEIVED NOV 04 2020 DART AEROSPACE LTD. 1-Box Fax: 779-2428-1665			
Comment:			



Via: Fedex Economy
Pymt Terms: Net 30
Freight Terms: Collect
Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	213469	D2646P	D2646 REV. C			Aft Cap : Various STC's AS PER DWG D2646 REV. C	Received	-	10/13/20	50 pcs	50 pcs	0 pcs	\$5.90/pcs	\$0.00
													Grand Total:	\$0.00

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

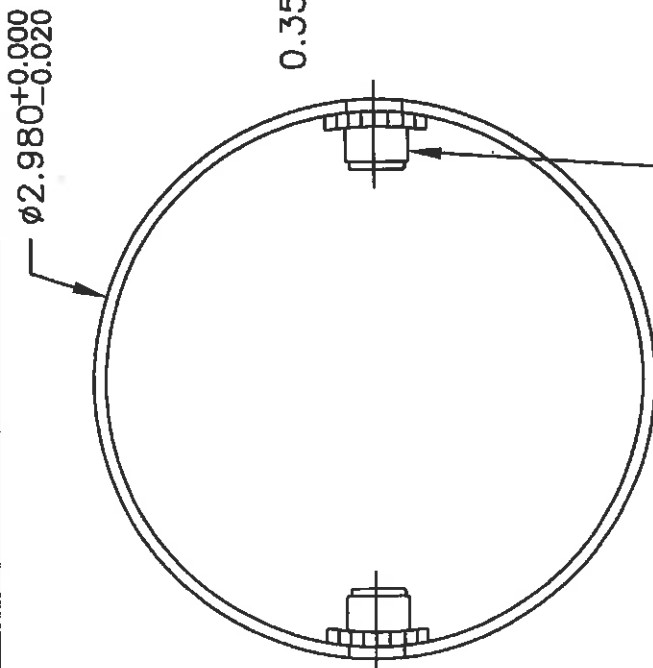
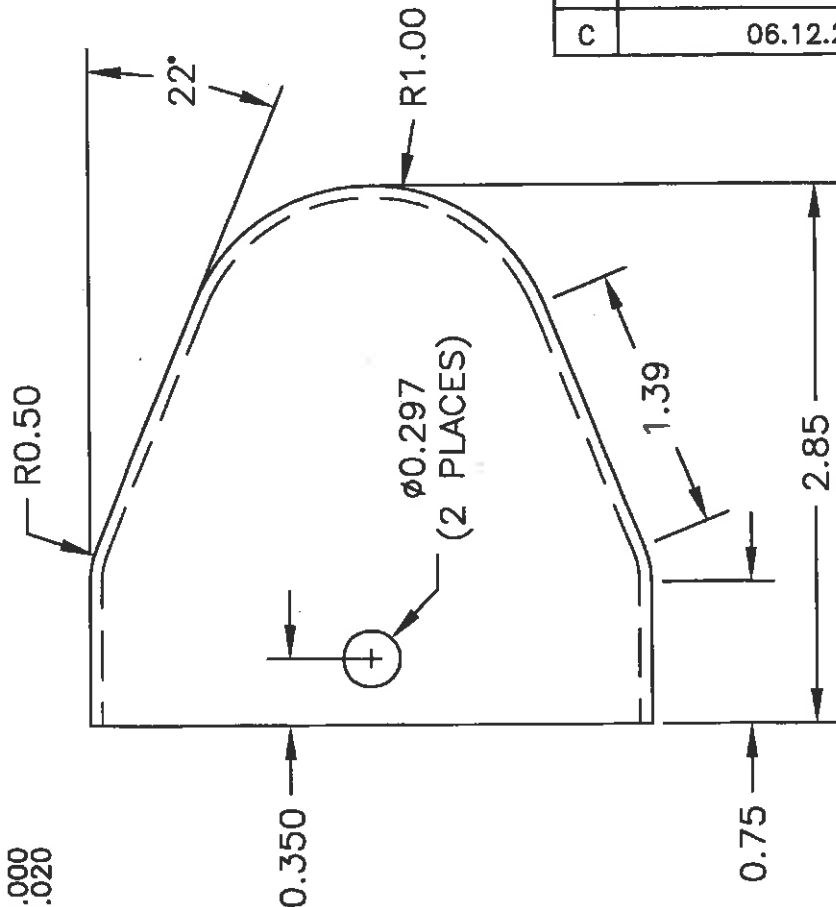
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Please ensure to send the related invoice to hby_ap@dartaero.com.



DESIGN DS		DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]		DRAWING NO. D2646	REV. C SHEET 1 OF 1
DATE 06.12.20			TITLE AFT CAP	SCALE 1:1
A	97.03.25		NEW ISSUE	
B	05.04.01		CHANGE TO CLOSED INSERTS	
C	06.12.20		CHANGE TO OPEN ENDED INSERTS	



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

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RELEASED

07.02.12

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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MEYER

MEYER ALUMINUM LIMITED

5 DAI LI STREET, TAI PO INDUSTRIAL ESTATE, TAI PO, N.T. HONG KONG
MILL TEST CERTIFICATE

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INVOICE : A19060717

We hereby certify that the material detailed below has been inspected and tested
and conforms to the requirements of the relevant specifications and/or order.

PAGE : Page 3 of 6

CERT NO : 19-812-C

DATE : Jul 20, 2019

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CUSTOMER NAME & ADDRESS : Meyer Aluminium Blanks, Inc., 141 Balsam Road, Theboygan Falls, WI 53085, U.S.A.				P.O.NO: PO10001				MATERIAL & SPECIFICATION : Material 1100-O Aluminium Sheets Specifications: ASTM B.09-14											
ITEM	DESCRIPTION & SIZE	FORM	ALLOY & TEMPER	INSPECTION NO	QTY. Lb	TENSILE PROPERTIES - ASTM B867-15					BEND PROPERTIES ASTM E293-14	CHEMICAL COMPOSITION - ASTM E1251-17a							
						Location	Temper	UTS ksi	YS ksi	ELONG %		Fe	Si	Mn	Cu	Zn	Other(Each)	Other(Total)	Al
3	Aluminium Sheets 0.063" x 120" x 48"	R	1100-O	Batch No. 19-1100-0007 CL19-880307	2829	Front End	O	13.2	4.9	38.0		0.45	0.16	0.01	0.06	0.00	<0.05	<0.15	99.90
						Back End	O	13.1	4.9	36.3									

1 kg/mm² = 1.42 ksi

Ver. 2019.05

Remark : The test results shown above are obtained from tests performed by the Meyer's in-house laboratory.



6236 205 Street Langley, B.C. Canada V2Y
1N7 Ph#: (604)530-7455 info@siegsmfg.com

INSPECTION REPORT

Date: October 28 2020

Customer: Dart Areospace

Packing Slip: 3101

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Part#:	Quantity	Material	Check holes	Insp. By.
D26 .5P ✓	50 ✓	14g ✓ aluminum 1100-0	N/A	KQ

Material Certification Attached: yes

Entered:

Date: DEC 09 2020

DART
AEROSPACE

NCR No.

20-8748

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: 213469 Part No. D2646		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐																															
Date : NOV 09 2020		Sequence #: 120		QTY Affected : 50 PCS		MRB (QSI042) INSP 12 20/11/10																													
Description Work Order Deviation				Disposition																															
DURING INSPECTION IT WAS FOUND THAT THE MATERIAL SPECIFICATIONS DOES NOT MATCH THE PART DRAWING: -DRAWING CALLS FOR QQ-A-250/1 -MILL TEST IS TO ASTM B209-14 (POH13047217) DAS 82 9-89				Acceptable. ASTM B209 is an appropriate spec for 1100 aluminum. All cap is not structural.				Completed By 20/11/10																											
								Lead hand / Supervisor DAS 9 9-89 20-11-11																											
								QC / QA Coordinator DAS 9 9-89 20-11-11																											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☒ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																																			